

Work Order ID 132108

Monday, April 27, 2015 9:57:22 AM

132108**ASAP**

Page 1

Item ID: D4049-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mounting Plate, LH
Start Date: 4/27/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/27/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: MCS Date: 15-04-27 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4049	B								

100		0.00				<u>4</u>	<u>0</u>		<u>Jm15-4-26</u>
100									

Waterjet
FLOW CNC Waterjet
304.125
Memo
1-Cut as per dwg D4049
Dwg Rev: B
Prog Rev: 3
2-Deburr

110	QC2- Inspect parts off machine FAI/FAIB	0.00				<u>4</u>	<u>0</u>		<u>Jm15-4-26</u>
110									

QC
Quality Control
Memo

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Monday, April 27, 2015 9:57:22 AM

132108

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Mounting Plate, LH

Start Date: 4/27/2015 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 4/27/2015 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Identify as per dwg & Stock Location: WAOO2 0.00

160

Packaging

Memo

0.00

DAS
6
9-89

APR 29 2015

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MLC

APR 29 2015

APR 29 2015

DQA: _____ Date: _____



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		OTHER : _____			

Picklist Print

Monday, April 27, 2015 9:57:25 AM

Page 1

Work Order ID: 132108

132108

Parent Item: D4049-3

D4049-3

Parent Item Name: Mounting Plate, LH

Start Date: 4/27/2015

Required Date: 4/27/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 10.01.12 verified by:EC
dwg revA DD 10.02.18 verified by:EC
IPP Rev:B as per

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	205.2917	0.1999	1			

M304S11GA

304/316 0.125 Sheet

Jun 15-4-26

Location

Loc Qty

Loc Code

MAT020

205.2917

122521

41

M128254

63

M129545

37.875

M129972

63.4167

129972

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
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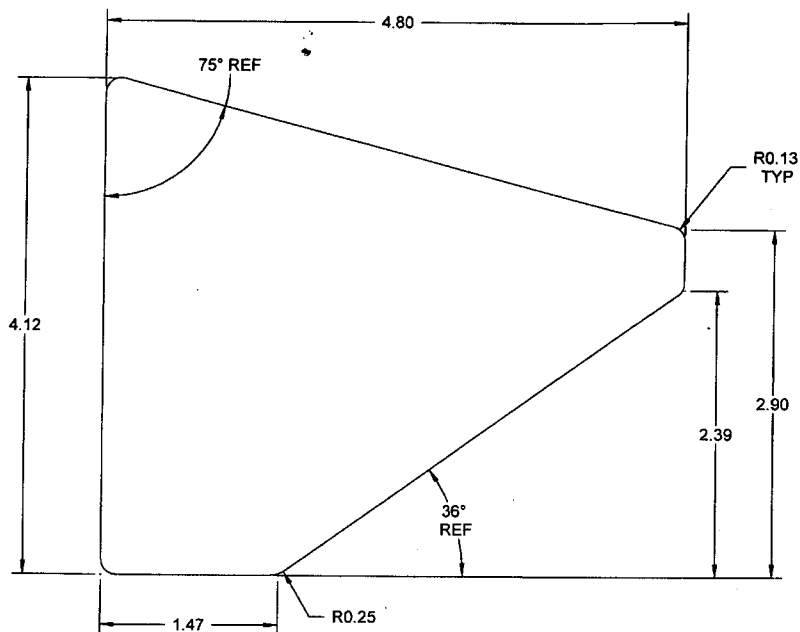


WORK ORDER NON-CONFORMANCE / UPDATE

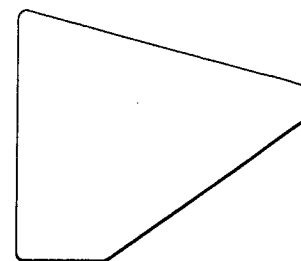
QA Closed: _____ Date: _____

Work Order update only ☐

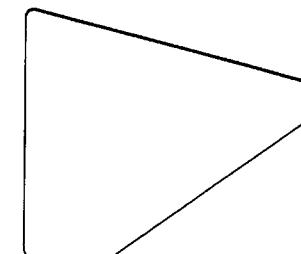
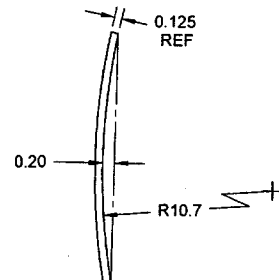
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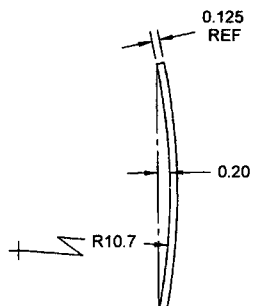
D4049-3F FLAT PATTERN



**D4049-3 MOUNTING PLATE, LH
(MAKE FROM D4049-3F FLAT PATTERN)**



**D4049-4 MOUNTING PLATE, RH
(MAKE FROM D4049-3F FLAT PATTERN)**



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH, 0.125" THICK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.46 lbs

STAMP COPY
UNCOMPLETED

NO 132108 MJS
150427

RELEASED
R 2010-04-14

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO. D4049	REV. B
MFG. APPR.	RF	SHEET 5 OF 7	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MOUNTING LUG ASSY	NTS
DATE	10.03.19	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



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